

Work Order ID 119516

Friday, May 16, 2014 12:59:37 PM

119516

Page 1

Item ID: D3542-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Bracket

Stop

NS2

Start Date: 5/15/14 Start Qty: 6.00

6

Cust Item ID:

Required Date: 5/15/14 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: MLD

Date: 14-05-22

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3542	Rev A

100 0.00 DAS 37 9-89 14.05.28
100 BAND SAW
Bandsaw Memo 0.00
Jeaspa Bandsaw Cut blank 4.0" long

110 0.00 DAS 37 9-89 14.05.28
110 HAAS CNC VERTICAL MACHINING #1
HAAS 1 Memo 0.00
HAAS CNC vertical machine #1 1- Mill as per Folio FA684 Rev: AA & Dwg D3542 Rev: A 2-Deburr per dwg D3443

120 0.00 DAS 37 9-89 14.05.28
120 QC2- Inspect parts off machine FAI/FAIB Memo 0.00
Quality Control

DQA:

Date:



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:

Date:

Work Order update only

Work Order: _____
 Part No. _____
 NCR No. _____

DISPOSITION

Rework
 Scrap
 Use-as-is
 Suspected Unapproved

Skid-tube
 Machining
 Thermoforming
 Large Fab

AGAINST DEPARTMENT/PROCESS

Crosstube
 Small Fab
 Finishing
 Composite

Water Jet
 Prod. Eng. Coor.
 Rec/Store/Packaging
 Supplier

Engineering
 Quality
 Other

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear	General			
	Bending	Bend	Folio/Program	Outside Dimensions
	Centre Not Concentric	BOM/Route	Grain	Over/Under tolerance
	Cracks	Broken/Damage/Defect	Hardware	Part Incorrect
	Crimp/Kink/Ripple/Wave	Burrs	Inspection Incomplete/Unqualified	Part Lost/Missing
	Cuffs	Contamination	Instructions Incomplete/Unclear	Part Moved
	Crushing	Countersink	Misaligned/off center	Positioned Wrong
	Heat Treat	Cut Too Short	Mislabeled	Power Loss/Surge
	Inspection Strip in Tube	Drawing	Misread	Pressure/Forced
	Marks/Chatter	Drill Holes	Off-set	Set-up
	Turning Sequence	Finish	Out of Calibration	Temperature/Cure
	Wave/Twist in Tube	Fit/Function	Out of Sequence	Weld
				Wrong Stock Pulled
				Other

Work Order ID 119516***119516***

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Item ID:	D3542-1	Accept	*N900040100*	Setup	Start	*NS1*	
Revision ID:					Stop	*NS2*	
Item Name:	Bracket						
Start Date:	5/15/14	Start Qty:	6.00	*6*	Cust Item ID:		
Required Date:	5/15/14	Req'd Qty:	6.00	*6*	Customer:		
Reference:							
Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	*NR1*
	QC:	Date:	SPC (Y/N):	Date:	Stop		*NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00							DAS 14 9-89 1405129
140 *140* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00							6 26/14-5-29
150 *150* Powdercoat Powder Coating	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3 11125024 Memo *** ENSURE TO MASK INSIDE BORE *** START TIME: 300° OVEN TEMPERATURE: 810 FINISH TIME: 840	0.00 0.00							6 14-6-3 DAS 9-89 1405129

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only

Work Order: _____	DISPOSITION			AGAINST DEPARTMENT/PROCESS					
Part No. _____	Rework <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>				
NCR No. _____	Scrap <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>				
	Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>				
	Suspected Unapproved <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>					

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear	General									
	<input type="checkbox"/> Bending	<input type="checkbox"/> Bend	<input type="checkbox"/> Folio/Program	<input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Pressure/Forced					
	<input type="checkbox"/> Centre Not Concentric	<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Grain	<input type="checkbox"/> Over/Under tolerance	<input type="checkbox"/> Set-up					
	<input type="checkbox"/> Cracks	<input type="checkbox"/> Broken/Damage/Defect	<input type="checkbox"/> Hardware	<input type="checkbox"/> Part Incorrect	<input type="checkbox"/> Temperature/Cure					
	<input type="checkbox"/> Crimp/Kink/Ripple/Wave	<input type="checkbox"/> Burrs	<input type="checkbox"/> Inspection Incomplete/Unqualified	<input type="checkbox"/> Part Lost/Missing	<input type="checkbox"/> Weld					
	<input type="checkbox"/> Cuffs	<input type="checkbox"/> Contamination	<input type="checkbox"/> Instructions Incomplete/Unclear	<input type="checkbox"/> Part Moved	<input type="checkbox"/> Wrong Stock Pulled					
	<input type="checkbox"/> Crushing	<input type="checkbox"/> Countersink	<input type="checkbox"/> Misaligned/off center	<input type="checkbox"/> Positioned Wrong	<input type="checkbox"/> Other					
	<input type="checkbox"/> Heat Treat	<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Mislabeled	<input type="checkbox"/> Power Loss/Surge						
	<input type="checkbox"/> Inspection Strip in Tube	<input type="checkbox"/> Drawing	<input type="checkbox"/> Misread							
	<input type="checkbox"/> Marks/Chatter	<input type="checkbox"/> Drill Holes	<input type="checkbox"/> Off-set							
	<input type="checkbox"/> Turning Sequence	<input type="checkbox"/> Finish	<input type="checkbox"/> Out of Calibration							
	<input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Fit/Function	<input type="checkbox"/> Out of Sequence							

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119516

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Item ID: D3542-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Bracket

Stop

NS2

Start Date: 5/15/14 Start Qty: 6.00

6

Cust Item ID:

Required Date: 5/15/14 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2

Sequence ID/
Work Center ID
160

Operation
Description
QC3- Inspect Part Finish

Set Up/
Run Hours
0.00 27
9.39

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC

Quality Control

M/6/3

6

170

Identify as per dwg & Stock Location: STO49 0.00

170

Packaging

Packaging

0.00

DAS
28
0.00

JUN 04 2014

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Quality Control

0.00

M/5 14-06-04

 M/6/4

DQA: _____ Date: _____

Date:



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only

Work Order: _____			DISPOSITION			AGAINST DEPARTMENT/PROCESS					
			Rework <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>				
Part No. _____			Scrap <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>				
NCR No. _____			Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>				
			Suspected Unapproved <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>					
Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector	
Design	<input type="checkbox"/>										
Doc/Data	<input type="checkbox"/>										
Equip/Tooling	<input type="checkbox"/>										
Handling/Pre	<input type="checkbox"/>										
Material	<input type="checkbox"/>										
Operator	<input type="checkbox"/>										
Offset/Setup	<input type="checkbox"/>										
Process	<input type="checkbox"/>										
Supplier	<input type="checkbox"/>										
Training	<input type="checkbox"/>										
Transport	<input type="checkbox"/>										
Unapproved	<input type="checkbox"/>										
FAULT CATEGORY											
Landing Gear			General								
Bending	<input type="checkbox"/>	Bend	<input type="checkbox"/>	Folio/Program	<input type="checkbox"/>	Outside Dimensions	<input type="checkbox"/>	Pressure/Forced	<input type="checkbox"/>		
Centre Not Concentric	<input type="checkbox"/>	BOM/Route	<input type="checkbox"/>	Grain	<input type="checkbox"/>	Over/Under tolerance	<input type="checkbox"/>	Set-up	<input type="checkbox"/>		
Cracks	<input type="checkbox"/>	Broken/Damage/Defect	<input type="checkbox"/>	Hardware	<input type="checkbox"/>	Part Incorrect	<input type="checkbox"/>	Temperature/Cure	<input type="checkbox"/>		
Crimp/Kink/Ripple/Wave	<input type="checkbox"/>	Burrs	<input type="checkbox"/>	Inspection Incomplete/Unqualified	<input type="checkbox"/>	Part Lost/Missing	<input type="checkbox"/>	Weld	<input type="checkbox"/>		
Cuffs	<input type="checkbox"/>	Contamination	<input type="checkbox"/>	Instructions Incomplete/Unclear	<input type="checkbox"/>	Part Moved	<input type="checkbox"/>	Wrong Stock Pulled	<input type="checkbox"/>		
Crushing	<input type="checkbox"/>	Countersink	<input type="checkbox"/>	Misaligned/off center	<input type="checkbox"/>	Positioned Wrong	<input type="checkbox"/>		<input type="checkbox"/>		
Heat Treat	<input type="checkbox"/>	Cut Too Short	<input type="checkbox"/>	Mislabeled	<input type="checkbox"/>	Power Loss/Surge	<input type="checkbox"/>		<input type="checkbox"/>		
Inspection Strip in Tube	<input type="checkbox"/>	Drawing	<input type="checkbox"/>	Misread	<input type="checkbox"/>	Other	<input type="checkbox"/>		<input type="checkbox"/>		
Marks/Chatter	<input type="checkbox"/>	Drill Holes	<input type="checkbox"/>	Off-set	<input type="checkbox"/>		<input type="checkbox"/>		<input type="checkbox"/>		
Turning Sequence	<input type="checkbox"/>	Finish	<input type="checkbox"/>	Out of Calibration	<input type="checkbox"/>		<input type="checkbox"/>		<input type="checkbox"/>		
Wave/Twist in Tube	<input type="checkbox"/>	Fit/Function	<input type="checkbox"/>	Out of Sequence	<input type="checkbox"/>		<input type="checkbox"/>		<input type="checkbox"/>		

Picklist Print

Page 1

Friday, May 16, 2014 12:59:41 PM

Work Order ID: 119516

119516

Parent Item: D3542-1

D3542-1

Parent Item Name: Bracket

Start Date: 5/15/14

Required Date: 5/15/14

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev: A New Issue 07-04-23 JLM
IPP Rev: B updated powder coat per NCR 07.05.16 EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B30000X01.5 00		Purchased	No			100	f	12.0000	0.3333333	2			DAS 37 9-88 14.05.28

M6061T6B30000X01.500

6061-T6 Bar 3.00 x 1.50

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT004	12	
M126075	12	24C.

DQA:

Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:

Date: _____

Work Order update only

Work Order: _____			DISPOSITION			AGAINST DEPARTMENT/PROCESS									
Part No. _____			Rework <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>								
NCR No. _____			Scrap <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>								
Suspected Unapproved <input type="checkbox"/>			Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>								
Root Cause	Date	Step	Qty	Description of work order update or non-conformance		Initial Chief Eng	Action Description		Sign & Date	Verification	QC Inspector				
Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport Unapproved															
FAULT CATEGORY															
Landing Gear	Bending <input type="checkbox"/>			General <input type="checkbox"/>			Folio/Program <input type="checkbox"/>			Outside Dimensions <input type="checkbox"/>			Pressure/Forced <input type="checkbox"/>		
	Centre Not Concentric <input type="checkbox"/>			Bend <input type="checkbox"/>			Grain <input type="checkbox"/>			Over/Under tolerance <input type="checkbox"/>			Set-up <input type="checkbox"/>		
	Cracks <input type="checkbox"/>			BOM/Route <input type="checkbox"/>			Hardware <input type="checkbox"/>			Part Incorrect <input type="checkbox"/>			Temperature/Cure <input type="checkbox"/>		
	Crimp/Kink/Ripple/Wave <input type="checkbox"/>			Broken/Damage/Defect <input type="checkbox"/>			Inspection Incomplete/Unqualified <input type="checkbox"/>			Part Lost/Missing <input type="checkbox"/>			Weld <input type="checkbox"/>		
	Cuffs <input type="checkbox"/>			Burrs <input type="checkbox"/>			Instructions Incomplete/Unclear <input type="checkbox"/>			Part Moved <input type="checkbox"/>			Wrong Stock Pulled <input type="checkbox"/>		
	Crushing <input type="checkbox"/>			Contamination <input type="checkbox"/>			Misaligned/off center <input type="checkbox"/>			Positioned Wrong <input type="checkbox"/>			Other <input type="checkbox"/>		
	Heat Treat <input type="checkbox"/>			Countersink <input type="checkbox"/>			Mislabeled <input type="checkbox"/>			Power Loss/Surge <input type="checkbox"/>					
	Inspection Strip in Tube <input type="checkbox"/>			Cut Too Short <input type="checkbox"/>			Misread <input type="checkbox"/>								
	Marks/Chatter <input type="checkbox"/>			Drawing <input type="checkbox"/>			Off-set <input type="checkbox"/>								
	Turning Sequence <input type="checkbox"/>			Drill Holes <input type="checkbox"/>			Out of Calibration <input type="checkbox"/>								
	Wave/Twist in Tube <input type="checkbox"/>			Finish <input type="checkbox"/>			Out of Sequence <input type="checkbox"/>								
	Fit/Function <input type="checkbox"/>														

DART AEROSPACE LTD	Work Order:	119516
Description: Bracket	Part Number:	D3542-1
Inspection Dwg: D3542	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

DAS

Measured by:	37 9-89
Date:	14-05-28

228

DAS
14
9-89
1405189

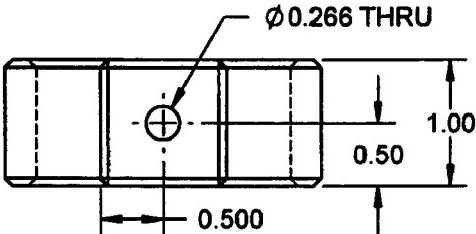
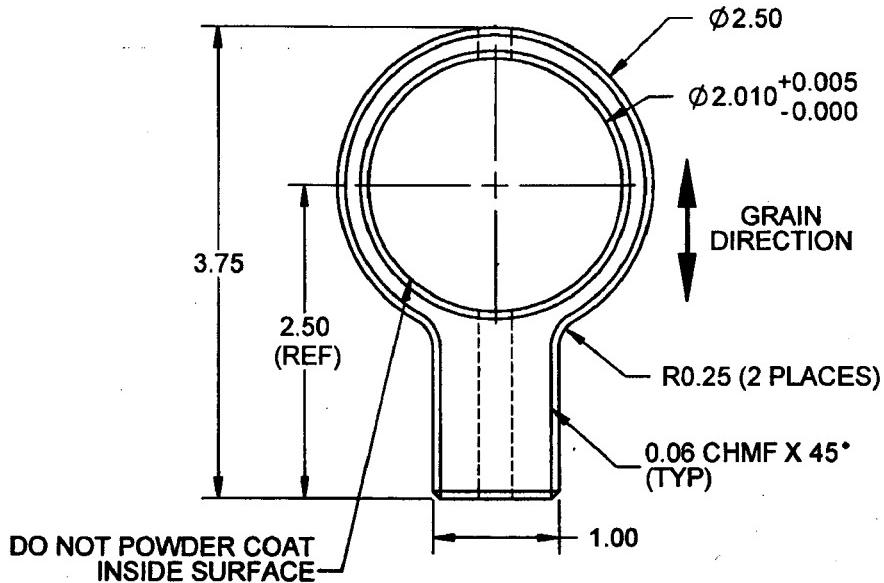
Prototype Approval:

N/A

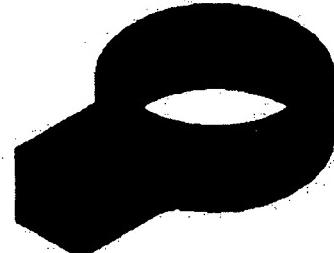
Rev	Date	Change	Revised by	Approved
A	07.06.13	New Issue	KJ/JLM <i>[Signature]</i>	<i>E</i>

DART

DESIGN <i>CE</i>	DRAWN BY <i>CE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED <i>B</i>	APPROVED <i>H</i>	DRAWING NO. D3542	REV. A	SHEET 1 OF 1
DATE 06.11.27		TITLE BRACKET	SCALE 2:3	
REV A	DATE 06.11.27	DESCRIPTION NEW ISSUE		

RELEASED
07 04 - 02**D3542-1 BRACKET**

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 119516 MLC
1405-22

**NOTES:**

- 1) MATERIAL: 6061-T6 ALUMINUM BAR PER QQ-A-225/8 OR QQ-A-200/8 OR AMS 4117/4128/4115/4116/4160 (REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDEX (4.3.5.6) PER DART QSI 005 4.3 EXCEPT WHERE NOTED
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3542-1" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

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